

80359

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Tooling:

Date:

Run Start *NR1*

SPC (Y/N):**Date:**

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80359

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February-17-12 12:55:26 PM

Item ID: D3660-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: CUFF
 Start Date: 17/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.A 12/03/26		4	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				H	BK	12-3-27.	
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	1	JM 12/03/27	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 80359

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Page 3

February-17-12 12:55:26 PM

Item ID: D3660-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: CUFF
 Start Date: 17/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/3/28 (4)
 12/3/29
 120328

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 80359

80359

Parent Item: D3660-1

D3660-1

Parent Item Name: CUFF

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6008-180		Manufactured	No			100	Each	12.0000	0.056	0.235789			

D6008-180

Crosstube Extrusion

**

20 12 3 26

Location

Loc Qty

Loc Code

LG

12

59249

12

46779

2.433'

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

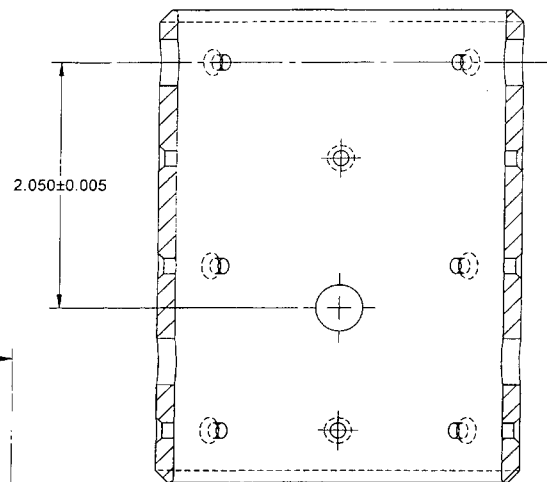
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

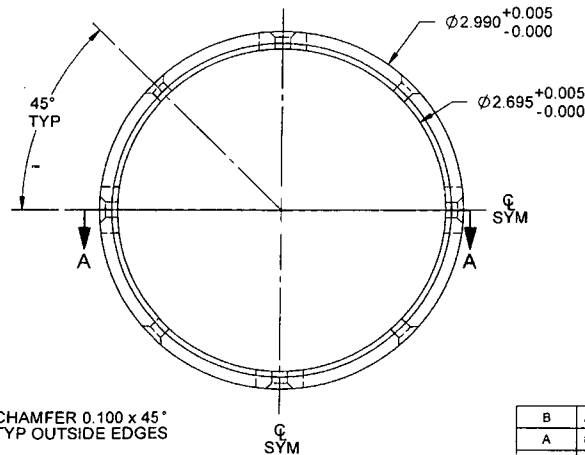
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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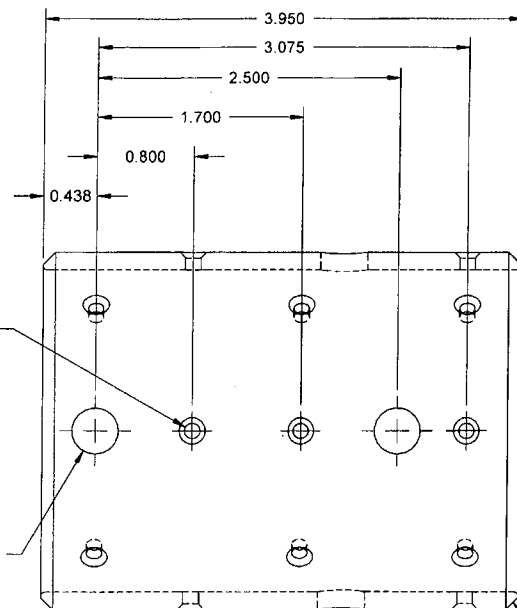
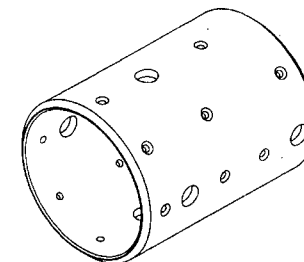
NOTE: Date & initial all entries



R0.032 TYP
INSIDE EDGES



D3660-1 CUFF



DRILL #30 ($\phi 0.128$ REF)
C/SINK $\phi 0.230 \times 100^\circ$
TYP 22 PLACES

$\phi 0.386^{+0.005}_{-0.000}$
HOLE TO BE ALIGNED
WITHIN ± 0.001 OF HOLE
ON OTHER SIDE OF CUFF,
TYP 6 PLACES

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WWW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 LBS

B	ADD $\phi 0.128$ & $\phi 0.386$ HOLES (B8)	CP	08.03.03	
A	NEW ISSUE	CP	07.07.07	
REV.	DESCRIPTION		BY DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3660 REV. B SHEET 1 OF 1 TITLE CUFF SCALE NTS		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE				08.03.03
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80359 M.C.J.
12/02/17

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